

**CLAIMS**

We claim:

1. A variable folder having a product strand path extending therethrough,  
2. said variable folder comprising:
  3. a cross-cutting arrangement including a cutting cylinder and at least one cutting  
4. blade carried on said cutting cylinder functional for cutting a product from a feeding web  
5. strand fed along the product strand path, said at least one cutting blade having a plurality of  
6. recesses functioning to leave residual crosspieces in said feeding web strand by which said  
7. product remains connected to said feeding web strand;
  8. a collecting cylinder located downstream of said cross-cutting arrangement along  
9. the product strand path;
  10. a product directing arrangement which leads from said cross-cutting  
11. arrangement to said collecting cylinder; and
  12. accelerating and tearing-off cams at a location between said cross-cutting  
13. arrangement and said collecting cylinder through which said product passes, said accelerating  
14. and tearing-off cams operable for gripping said product to tear off said product from said  
15. feeding web strand at said residual crosspieces.
1. 2. A variable folder according to claim 1, wherein said cutting blade has  
2. three recesses, said recesses being arranged to register with border regions and a center of said  
3. feeding web strand.

1                   3.       A variable folder according to claim 1, wherein each residual crosspiece  
2        has an accelerating and tearing-off cam associated therewith.

1                   4.       A variable folder according to claim 1, wherein said accelerating and  
2        tearing-off cams are arranged to register with print-free regions of said feeding web strand.

1                   5.       A variable folder according to claim 1, further comprising first and  
2        second drawing arrangements arranged one after another upstream of said cross-cutting  
3        arrangement, said first and second drawing arrangements each operating at a circumferential  
4        speed which is greater than a speed of said feeding web strand received from upstream printing  
5        units by a lead which is adjustable.

1                   6.       A variable folder according to claim 5, further comprising a third  
2        drawing arrangement arranged between said cross-cutting arrangement and said accelerating  
3        and tearing-off cams, said third drawing arrangement being operable at the circumferential  
4        speed of said first and second drawing arrangements.

1                   7.       A variable folder according to claim 6, wherein said accelerating and  
2        tearing-off cams are operable at a higher circumferential speed than the circumferential speed  
3        at which said first, second and third drawing arrangements are operable.

1                   8.       A variable folder according to claim 1, further comprising a driven  
2        roller, said accelerating and tearing-off cams interacting with said driven roller.

1                   9.       A variable folder according to claim 8, wherein a ratio of a speed of said  
2       driven roller to a speed of said accelerating and tearing-off cams is other than a whole number.

1                   10.      A variable folder according to claim 1, wherein said product-directing  
2       arrangement comprises a belt directing system which in operation is product non-engageable.

1                   11.      A variable folder according to claim 1, wherein said product-directing  
2       arrangement comprises tongues.